

# Work Order ID 81461

**\*81461\***

Page 1

Wednesday, March 14, 2012 11:01:46 AM

Item ID: D4091-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Mounting Lug  
 Start Date: 3/14/2012 Start Qty: 30.00 **40**  
 Required Date: 3/30/2012 Req'd Qty: 30.00 **\*30\***  
 Reference: **\*30\*** Cust Item ID:  
 Customer:

Approvals: Process Plan: mf Date: 12-03-14 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_  
 Run Start **\*NR1\***  
 Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4091	A								

100 0.00  
**\*100\***  
 Bandsaw Memo 0.00  
 Jeaspa Bandsaw CUT BLANK 1.450" LONG  
CY 12/03/15

110 0.00  
**\*110\***  
 HAAS 1 perch. Memo 0.00  
 HAAS CNC vertical machine #1 MACHINE AS PER FOLIO FA920 AND DWG  
 FOLIO REV: \_\_\_\_\_  
 DWG REV: \_\_\_\_\_  
at @ meter  
#3  
CY 12/03/15 (30)

DEBURR  
 issue 7/0 to meter  
 machine as per dwg D 4091 REC. A  
 P/O: 16451

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

**Work Order ID 81461**

Wednesday, March 14, 2012 11:01:46 AM

**\*81461\***

Page 3

Item ID: D4091-1

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Mounting Lug

Start Date: 3/14/2012 Start Qty: 30.00

**\*30\***

Cust Item ID:

Required Date: 3/30/2012 Req'd Qty: 30.00

**\*30\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

**\*150\***

Powdercoat

Memo

0.00

Powder Coating

S-1h10  
T-320°F  
F-1h40

M120222

40 ~~Q~~ (2P) 1404/03

160

QC3- Inspect Part Finish

0.00

**\*160\***

QC

Memo

0.00

Quality Control

40 ~~PL~~ 12-4-3

170

Identify as per dwg & Stock Location: 458

0.00

**\*170\***

Packaging

Memo

0.00

Packaging

12/4/34 400

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID 81461****\*81461\***

Page 4

Wednesday, March 14, 2012 11:01:46 AM

Item ID: D4091-1

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Mounting Lug

Start Date: 3/14/2012 Start Qty: 30.00

**\*30\***

Cust Item ID:

Required Date: 3/30/2012 Req'd Qty: 30.00

**\*30\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

Memo

0.00

Quality Control

12/14/12  
CZ 12/04/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

Wednesday, March 14, 2012 11:01:45 AM

Page 1

Work Order ID: 81461

Parent Item: D4091-1

Parent Item Name: Mounting Lug

Start Date: 3/14/2012

Required Date: 3/30/2012

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP REV :A NEW ISSUE 10-03-31 JLM. VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2423 Lug Extrusion		Manufactured	No			100	f	321.6600	0.1251	3.9505263			

Location

Loc Qty

Loc Code

MAT006

321.66

43722

161.5

45800

1

68331

159.16

CL 12/03/15

~~395~~ 5.20

D 4091-1 P

CL 12/03/15 (34)

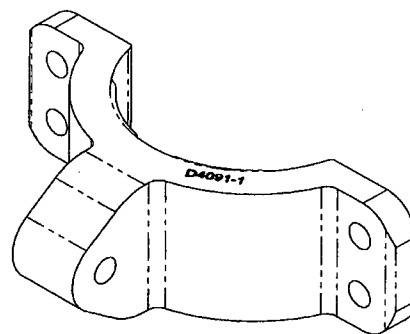
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D4091-1 MOUNTING LUG**

# 81461

**RELEASED**  
2010-06-28  
WJB

**NOTES:**

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF  $0.010 \pm 0.005$  IN THIS LOCATION WITH A TOOL TIP RADIUS OF  $0.015 \pm 0.005$
- 7) WEIGHT: 0.31 lbs

A		NEW ISSUE		CP	10.03.29
REV.		DESCRIPTION		BY	DATE
DESIGN	CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA			
DRAWN	CP				
CHECKED		DRAWING NO.	D4091	REV. A	
MFG. APPR.				SHEET 1 OF 2	
APPROVED		TITLE	MOUNTING LUG	SCALE	
DE APPR.				NTS	
DATE	10.03.29	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

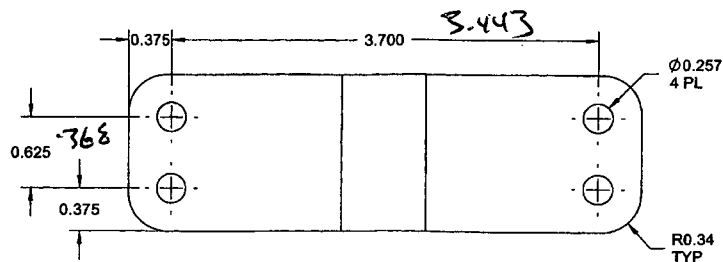
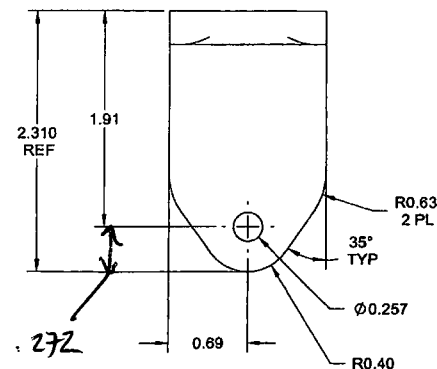
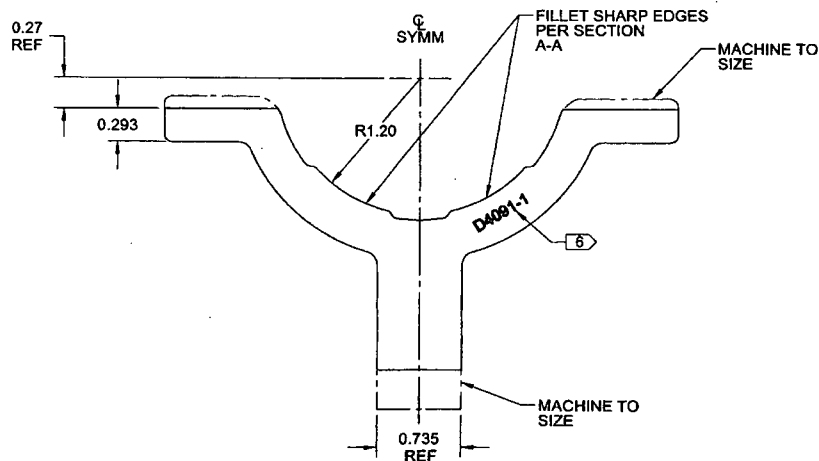
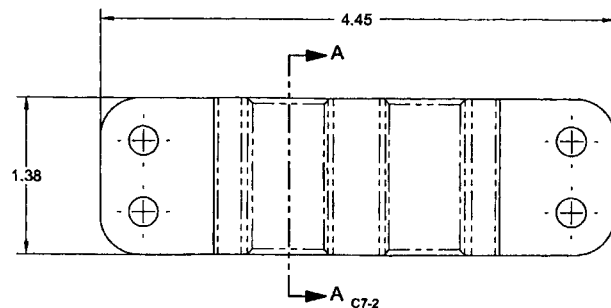
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**NOTE:** Date & initial all entries



R0.03-R0.07  
TYP AROUND PAD

**SECTION A-A** C5-2



**D4091-1 MOUNTING LUG**

#81461

**RELEASED**  
2010-04-20

DESIGN	GP	<b>DART AEROSPACE LTD</b>	
DRAWN	GP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D4091</b>	REV. A
MFG. APPR.		TITLE	SHEET 2 OF 2
APPROVED		<b>MOUNTING LUG</b>	SCALE
DE APPR.			NTS
DATE	10.03.29	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 81461
<b>Description:</b> Mounting Lug		<b>Part Number:</b> D4091-1
<b>Inspection Dwg:</b> D4091	<b>Rev:</b> a	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.38	+/-0.030					
4.45	+/-0.030					
0.27 REF	+/-0.030					
1.91	+/-0.030					
0.69	+/-0.030					
0.293	+/-0.010					
0.735 REF	+/-0.010					
0.375	+/-0.010					
3.700	+/-0.010					
0.625	+/-0.010					
0.375	+/-0.010					
Ø0.257	+0.006/-0.001					
R0.40	+/-0.030					
2.310 REF	+/-0.010					

<b>Measured by:</b>		<b>Audited by:</b>		<b>Preliminary Approval:</b>	
<b>Date:</b>		<b>Date:</b>		<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A	10.08.05	New Issue	KJ	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

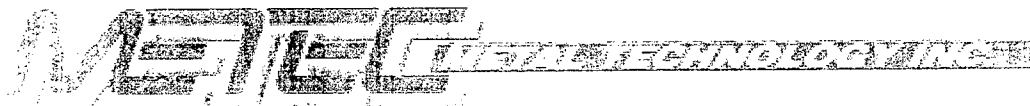
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 [metec@metec.ca](mailto:metec@metec.ca)

---

## CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
30	D4091-1-1	Mounting Lug	16451

MATERIAL: supplied by DART B68331

We hereby certify that the above parts were made in conformance with applicable drawings.

*METEC Metal Technology Inc.*

Jan Norris

Vankleek Hill, March 27, 2012

20 Terry Fox Drive  
Vankleek Hill, Ontario K0B 1R0 , Canada  
Tel: (613) 678-3957  
Fax: (613) 678-3956

**Delivery Slip No.:** 18528

Date: Mar 27, 2012

Page: 1

<b>Sold to:</b>	<b>Ship to:</b>
<b>Dart Aerospace Ltd.</b> Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
<b>Order No.:</b> PO16451	<b>Sold By:</b> Dewar, Eric
<b>Shipped By:</b> your truck	<b>Ship Date:</b> Mar 27, 2012

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D3910-1 Crosstube Lug as per drawing D3910 REV.B B81474	Each	40		
D2230-3 Mounting Lug as per drawing D 2230 REV.G B81558	Each	200		200
D4091-1 Lug as per drawing D4091 Rev.AB81461	Each	30	30	
3910-3 Crosstube Lug as per drawing D3910 REV.B B81459	Each	40		
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				
Received by: _____		Thank you for your order!		



**Invoice No.:** 9033  
**Date:** Mar 27, 2012  
**Page:** 1

**Dart Aerospace Ltd.**  
 Att. Linda Lacelle  
 1270 Aberdeen Street  
 Hawkesbury, Ontario K6A 1K7

**Shipping Address**  
 Dart Aerospace Ltd.  
 Att. Linda Lacelle  
 1270 Aberdeen Street  
 Hawkesbury, Ontario K6A 1K7

<b>P.O. Number</b> PO16451		Shipped by your truck Delivery Slip #: 18528		Terms: 2%/10, Net 30. Due Apr 26, 2012.		
Description	Quantity ordered	Quantity shipped	Quantity on B/O	Unit	Unit Price	Amount
D3910-1 Crosstube Lug as per drawing D3910 REV.B B81474	40			Each	31.55	
D2230-3 Mounting Lug as per drawing D 2230 REV.G B81558	200		200	Each	13.60	
D4091-1 Lug as per drawing D4091 Rev.AB81461	<del>80</del> 40	40		Each	26.95	1,078.00
3910-3 Crosstube Lug as per drawing D3910 REV.B B81459	40			Each	31.55	
Subtotal:						1,078.00
H - HST 13%						
HST						140.14
<b>Thank you for your order!</b>  HST # 867 061 723 RT0001 Interest on overdue accounts is charged at 24% per year						
<b>Total in CAD</b>						1,218.14

METEC Metal Technology Inc. 20 Terry Fox Drive P.O. Box 781 Vankleek Hill ON K0B 1R0 Canada  
 Tel. 1-613-678-3957 & 1-613-678-2782 Fax 1-613-678-3956 www.metec.ca



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0  
Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 [metec@metec.ca](mailto:metec@metec.ca)

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Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

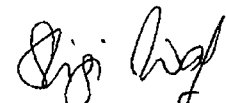
same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
40	D4091-1	Lug	16451

MATERIAL: supplied by DART B68331

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

  
Shigi Walz

Vankleek Hill, March 27, 2012